

Work Order ID 67510

Saturday, March 26, 2011 9:00:17 AM



Ship Apr '11

Page 1

Item ID:	D4030-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Assembly, Light Lid (350)			Stop		
Start Date:	3/28/2011	Start Qty:	1.00			
Required Date:	4/7/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>11-03-27</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

E Sa / 04 / 01 (1)

E Sa / 04 / 01 (1)

E Sa / 04 / 01

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries





Work Order ID 67510

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Saturday, March 26, 2011 9:00:17 AM

Item ID: D4030-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Long Basket Assembly, Light Lid (350)
Start Date: 3/28/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/7/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PP 67809</i>	0.00 0.00							<i>Per 4/10</i> 
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/4/11</i>  <i>ME</i> <i>11-4-01</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:00:10 AM

Page 1

Work Order ID: 67510

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)





Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P & NAS1149C0432R 10.06.16 DD
VERF:EC IPP Rev:D as per
dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	16.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST506</div> <div>16</div> <div></div> </div>													
<div> <div>66171</div> <div>9</div> <div></div> </div>													
<div> <div>66563</div> <div>7</div> <div></div> </div>													
D2535  Spring		Manufactured	No			100	Each	71.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST504</div> <div>71</div> <div></div> </div>													
<div> <div>64280</div> <div>21</div> <div></div> </div>													
<div> <div>66764</div> <div>50</div> <div></div> </div>													
D2537  Bushing		Manufactured	No			100	Each	61.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST504</div> <div>61</div> <div></div> </div>													
<div> <div>65077</div> <div>19</div> <div></div> </div>													
<div> <div>66972</div> <div>42</div> <div></div> </div>													
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			

B6754

SR 11/04/01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:00:11 AM

Page 2

Work Order ID: 67510

Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)



Start Date: 3/28/2011

Required Date: 4/7/2011



Start Qty: 1.00

Required Qty: 1.00



D3915-041	Manufactured	No	100	Each	0.0000	1	1
							<u>SA 11/04/01</u>
Light Lid Assembly, Long Basket							

D3917-3	Manufactured	No	100	Each	33.0000	6	6
							<u>SA 11/04/01</u>
Washer							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST092	33	
57144	1	
66903	32	

D3953-3	Manufactured	No	100	Each	5.0000	2	2
							<u>SA 11/04/01</u>
Gas Spring Stud, Lid							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	5	
65620	5	

D3953-7	Manufactured	No	100	Each	8.0000	2	2
							<u>SA 11/04/01</u>
Spring Spacer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	8	
65053	1	
65621	7	

D3953-9	Manufactured	No	100	Each	22.0000	2	2
							<u>SA 11/04/01</u>
Gas Spring Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST089	20	
66162	20	
ST096	2	
60008	2	

Saturday, March 26, 2011 9:00:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Saturday, March 26, 2011 9:00:12 AM

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Work Order ID: 67510

Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/28/2011

Required Date: 4/7/2011



Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No 100 Each 13.0000 2 2

Gas Spring Spacer  SB 11604601



Location Loc Qty Loc Code

ST096 12 2
65138 12
ST101 1
57143 1

D3953-19 Manufactured No 100 Each 10.0000 1 1

Gas Spring Bracket  SB 11604601



Location Loc Qty Loc Code

ST096 10
59213 1
64810 9 1

D3953-21 Manufactured No 100 Each 10.0000 1 1

Gas Spring Bracket  SB 11604601

Location Loc Qty Loc Code

ST096 10
66110 10 1

D3969-3 Manufactured No 100 Each 6.0000 1 1

Spring (Basket Lid)  SB 11604601

Location Loc Qty Loc Code

ST272 6
64285 6 1

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Saturday, March 26, 2011 9:00:12 AM

Work Order ID: 67510

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-14A Purchased No 100 Each 55.0000 4 4



Bolt



SS 11/04/01

Location Loc Qty Loc Code

ST351 55

115108 5

116978 50

1
3

AN3-20A Purchased No 100 Each 42.0000 2 2



Bolt



SS 11/04/01

Location Loc Qty Loc Code

ST352 42

105125 2

115371 40

2

AN4-12 Purchased No 100 Each 46.0000 3 3



Bolt



SS 11/04/01

Location Loc Qty Loc Code

ST357 46

116786 46

3

AN5-17A Purchased No 100 Each 80.0000 2 2



Bolt



SS 11/04/01

Location Loc Qty Loc Code

ST339 80

116590 80

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Saturday, March 26, 2011 9:00:13 AM

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Work Order ID: 67510

Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/28/2011

Required Date: 4/7/2011



Start Qty: 1.00

Required Qty: 1.00

AN5-21A	Purchased	No	100	Each	46.0000	2	2
							<u>SS 11/04/01</u>
Bolt							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST339	46	
114714	46	<u>2</u>

AN310-4	Purchased	No	100	Each	33.0000	3	3
							<u>SS 11/04/01</u>
NUT							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST324	33	
116786	33	<u>3</u>

AN310C4	Purchased	No	100	Each	39.0000	2	2
							<u>SS 11/04/01</u>
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST324	39	
116741	39	<u>2</u>

MS21042L3	Purchased	No	100	Each	2,187.000	6	6
							<u>SS 11/04/01</u>
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	2187	
116391	587	<u>6</u>
116540	800	
116549	800	

D4036-220

W 11.04.01

B 58309

1 SS 11/04/01

Saturday, March 26, 2011 9:00:14 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Saturday, March 26, 2011 9:00:14 AM

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Work Order ID: 67510

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased No

100

Each

890.0000

4

4



Nut



SS 11/04/01

Location

Loc Qty

Loc Code

ST300

890

114813

26

115594

168

116105

496

116548

200

4

MS24665-151

Purchased No

100

Each

507.0000

3

3



Cotter Pin



SS 11/04/01

Location

Loc Qty

Loc Code

ST309

507

17566

507

3

MS24665-300

Purchased No

100

Each

108.0000

2

2



Cotter Pin



SS 11/04/01

Location

Loc Qty

Loc Code

ST309

108

110123

8

116823

100

2

NAST149C0432R

ALL 04.01

NAST149F0432P

GNB TIME ONLY!

Purchased No

100

Each

106.0000

6

6



Washer



SS 11/04/01

REASON: NO STOCK.

~~11/04/01~~

Location

Loc Qty

Loc Code

ST275

106

112940

92

114405

1

116169

1

116737

12

6

1116900

Saturday, March 26, 2011 9:00:14 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Saturday, March 26, 2011 9:00:14 AM

Page 7

Work Order ID: 67510

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

110.0000

4

4



Washer



SS 11604601

Location

Loc Qty

Loc Code

ST275

110

114576

110

4

NAS1149F0332P

Purchased

No

100

Each

64.0000

8

8



WASHER



SS 11604601

Location

Loc Qty

Loc Code

ST275

64

18057

64

8

NAS1149C0432R

Purchased

No

100

Each

1,796.000

2

2



Washer



SS 11604601

Location

Loc Qty

Loc Code

ST297

1796

114292

12

116304

73

116805

19

116900

1692

2

Saturday, March 26, 2011 9:00:14 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

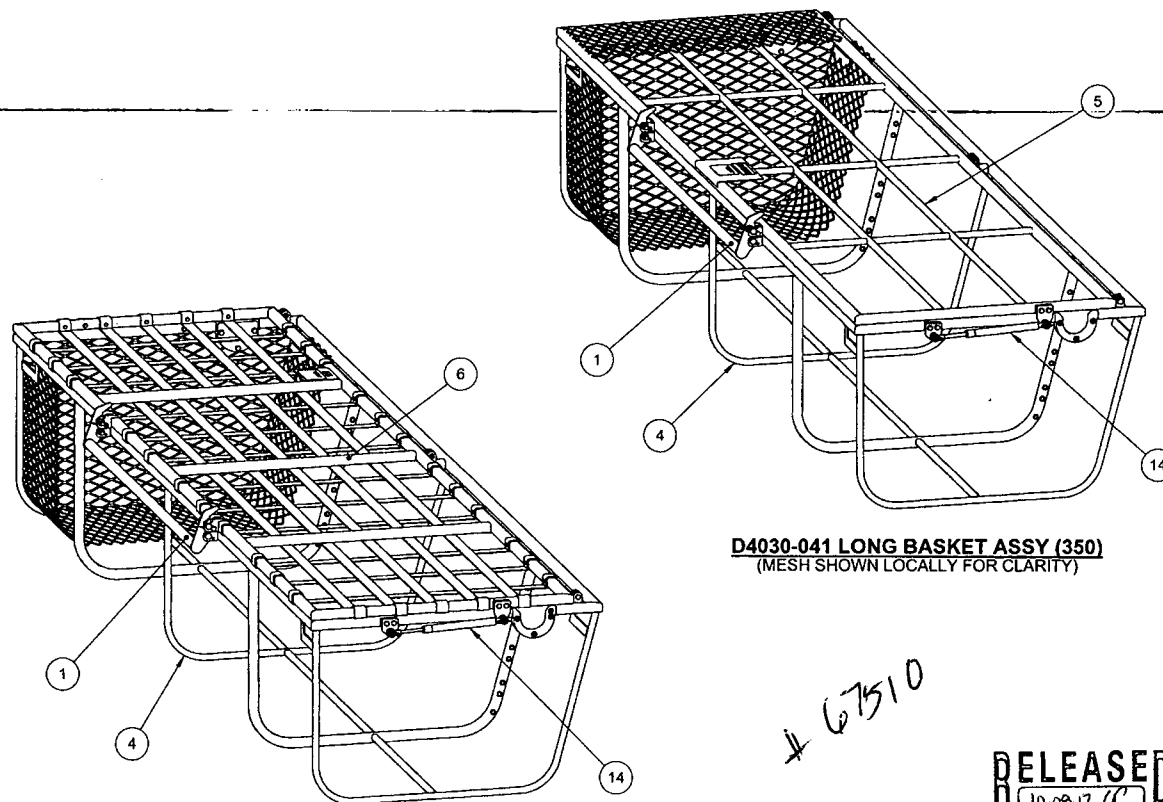
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (D6-1); ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED			
MFG. APPR.	JFS		
APPROVED			
DE APPR.			
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) SCALE _____ SHEET 1 OF 3 REV. C NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
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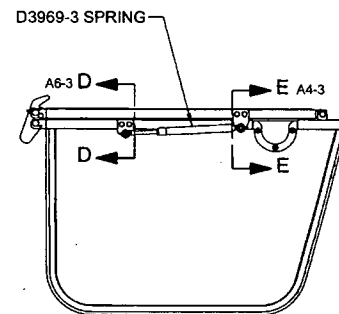
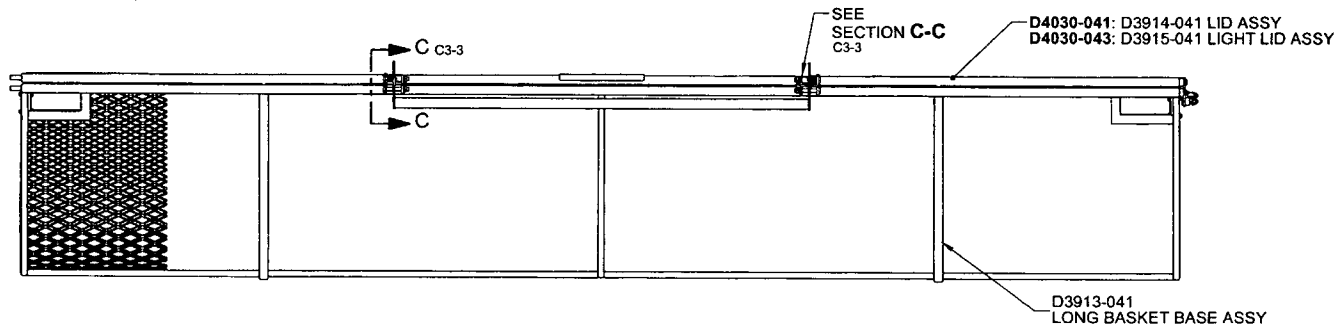
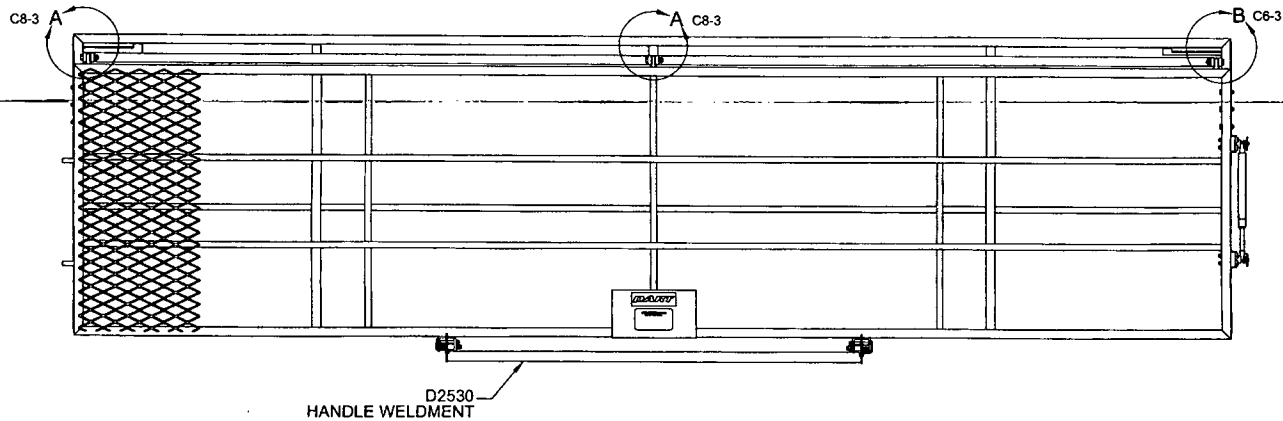
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8 7 6 5 4 3 2 1



#67510

D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4030	REV. C
MFG. APPR.	SE	SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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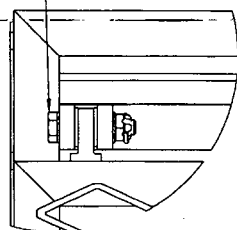
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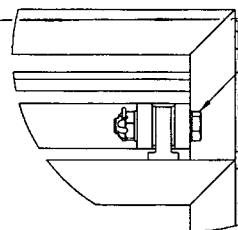
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



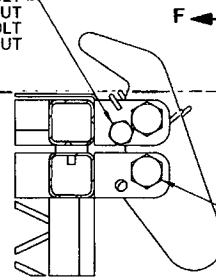
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

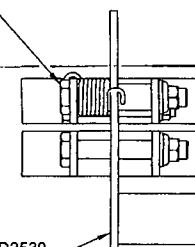


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

#67510

RELEASED
10.08.12

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. BTLA	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries